

Work Order ID 73294

Wednesday, August 31, 2011 10:43:58 AM



Page 1

Item ID: D2646

Accept



Setup Start



Revision ID:

Item Name: Aft Cap

Stop



Start Date: 9/1/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 60.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL

Date: 11/09/01

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2646 | Rev C | | | | | | | | |
| 100 | | 0.00 | | | | | | | |
| | PURCHASING | | | | | | | | |
| Purchasing | Memo | 0.00 | | | | | | | |
| Purchasing | Issue P/O: <u>14796</u> <input type="checkbox"/> 1-Spin as per Dwg D2646 <input type="checkbox"/> 2-Material release note required | | | | | | | | |
| 110 | | 0.00 | | | | | | | |
| | Receive & Inspect for Damage & Mat'l Certs | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Ensure Material Release Note is attached | | | | | | | | |
| 120 | | 0.00 | | | | | | | |
| | QC6- Inspect dimensions to drawing | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

CL 11/09/01 60

11/9/22 (CL)

counts
(CL)

8/10/23

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Dart Aerospace Ltd

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Item Name: Aft Cap

Start Date: 9/1/2011 Start Qty: 60.00



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Required Date: 9/15/2011 Req'd Qty: 60.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

60X of m/l 11/10/19

170

QC3- Inspect Part Finish

0.00



QC

Memo

Quality Control

180

Small Fab

0.00



Small Fab

Memo

Small Fab

Install inserts as per Dwg D2646

0.00

60 of m/l 11/10/21

60 of m/l 11/10/21

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

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Item Name: Aft Cap

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Start Date: 9/1/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 60.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|-----------------------------------|---|----------------------|---------|--------|--------------|------------------------------|---------------|------------------|------------------------------|
| 190 QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | | | <i>counted</i> <i>x60</i> | | | |
| 200 Packaging Packaging | Identify as per dwg & Stock Location: <u>FR-2</u> Memo | 0.00 0.00 | | | | <i>x60</i> <i>counted</i> | <i>0</i> | <i>0</i> | <i>11/10/21</i> |
| 210 QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | <i>11/10/24</i> <i>60</i> |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Wednesday, August 31, 2011 10:43:55 AM

Page 1

[illegible]

Required Qty: 60.00

| | | | |
|-----------|-----------------|----------|----|
| IPP rev I | changed inserts | 07.06.11 | EC |
|-----------|-----------------|----------|----|

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| ALS7-1032-130 | | Purchased | No | | | 110 | Each | 1,155.000 | 2 | 120 | | | |
| | | | | | | | | | | | | 4/10/21 | |
| Insert | | | | | | | | | | | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST282 | | 1155 | | N1118966 | | X120 | | | |
| | | | | | 117717 | 899 | | | | | | | |
| | | | | | 118386 | 256 | | | | | | | |
| D2646P | | Purchased | No | | | 180 | Each | 0.0000 | 1 | 60 | | | |
| | | | | | | | | | | | | 6/4/22 (60) | |
| Aft Cap | | | | | | | | | | | | | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

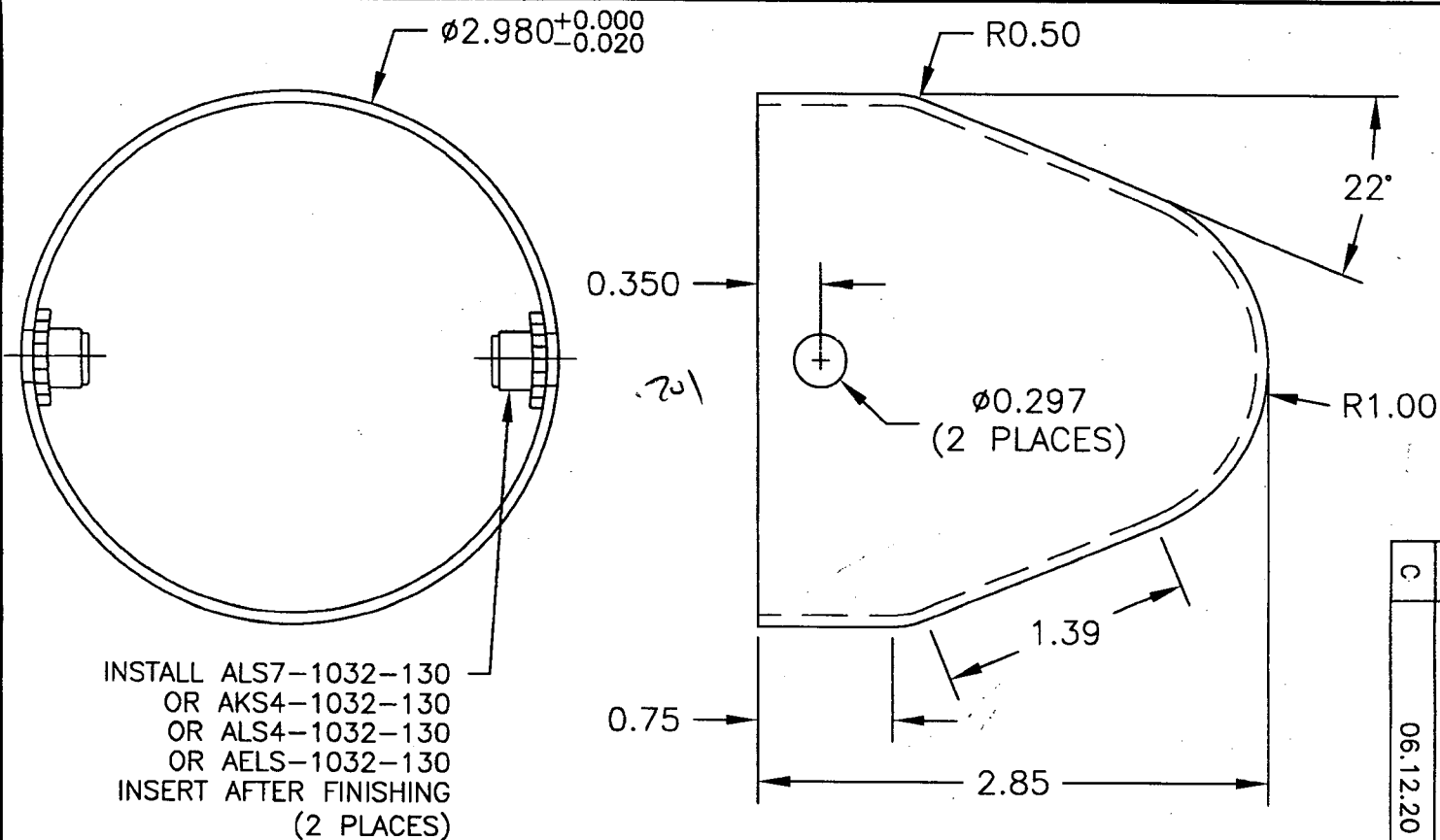
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

| DESIGN | DS | DRAWN BY | DART AEROSPACE USA, INC. | PORT HADLOCK, WA | REV. C |
|---------|--------------------|----------|------------------------------|------------------|--------------|
| CHECKED | <i>[Signature]</i> | APPROVED | DRAWING NO. | D2646 | SHEET 1 OF 1 |
| DATE | 06.12.20 | | TITLE | AFT CAP | SCALE |
| | | | | | 1:1 |
| A | | 97.03.25 | NEW ISSUE | | |
| B | | 05.04.01 | CHANGE TO CLOSED INSERTS | | |
| C | | 06.12.20 | CHANGE TO OPEN ENDED INSERTS | | |



D2646 AFT CAP

- 1) MATERIAL: ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
07.02.02

CL11/09/01
W10:73294

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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| | | | | | | | | |

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613.632.9577
Fax: 613.632.1053

PURCHASE ORDER

Purchase Order ID PO14796

Purchase Order Date 9/1/2011

PO Print Date 9/1/2011

Page Number 1 of 1

Order From :

VC-SIE001

SIEG'S MANUFACTURING LTD.
6236 - 205 STREET
LANGLEY, BC V2Y 1N7
CA

Contact Name

Vendor Phone

604 530 7455

Vendor Fax

604 530 7490

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

CL 11/10/12

| Line Nbr | Reference Revision ID Vendor Part Number | Description/ Mfg ID | Req Date/ Taxable | Req Qty/ Unit of Measure | Ship Method | Unit Price | Extended Price |
|----------|--|------------------------|----------------------|-----------------------------|------------------|------------|-------------------|
| 1 | D2646P | Aft Cap | 9/16/2011 Yes | 60.00 Each | FedEx PI collect | \$6.4700 | \$388.20 |

Special Inst: SPIN AS PER DWG D2646 REV. C
B73294

PO Total:

\$388.20

MATERIAL CERTIFICATION
REQD UPON DELIVERY

CERTIFICATE OF CONFORMITY
REQD UPON DELIVERY

Change Nbr: 1

Change Date: 9/1/2011

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



Sieg's Manufacturing Ltd. Packing Slip

Metal Spinning & Metal Fabricating

6236 205 Street

Langley, BC, Canada V2Y 1N7

Phone:(604)530 7455 Fax:(604)530-7490

Check out our website: www.siegsmf.com

Packing Slip No.:

39740

Date:

09/15/2011

Page:

1

| | | | |
|--|--|--|--|
| Sold to: | | Ship to: | |
| DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7 | | DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7 | |
| Order No.: 14796 | | Sold By: KAULBARS, ARLA | |
| Shipped By: | | Ship Date: 09/15/2011 | |
| Tracking No.: | | | |

| Item No. | Unit | Description | Quantity |
|----------|------|-------------|----------|
| D2646P | Each | Aft Cap | 60 |
| Comment: | | | |



Sieg's Manufacturing Ltd.

6236 205 Street Langley, B.C. Canada V2Y 1N7

Ph#: (604)530-7455 fax#: (604)530-7490

arla@siegsmf.com

INSPECTION REPORT

Date: Sept 15, 2011

Customer: Dart Areaspace

Packing Slip: 39740

| Part#: | Quantity | Material | Check holes | Insp. By. |
|--------|----------|------------|----------------|--------------|
| D2646P | 60 | cb4 1100-0 | N/A | JD |
| | | | | |
| | | | | |
| | | | | |
| | | | | |

Notes:

Material Certification Attached: ☒

(THU) FEB 17 2011 9:01/No. 6831270819 P 4
FROM LEVELTEK 219-326-8536



Alumax Mill Products, Inc.
(an Alcoa Inc. business)
1480 Manheim Pike
Lancaster, Pa. 17601

Certification of Test Results

CERT NO 0001275543
DATE 1/31/2011
SKID NO 969493
SKID WGT 9,714
PAGE 1 OF 1

COPPER & BRASS SALES INC
22355 WEST ELEVEN MILE ROAD
SOUTHFIELD, MI 48034

LEVELTEK
3236 STATE ROAD 39
PO BOX 148
LA PORTE, IN 46352

| | | | | | |
|----------|--------|---------|----------------|--------|--------|
| ORDER NO | LO2114 | PO NO | 5400084918-R01 | | |
| ITEM NO | 1 | PART NO | ALFLR01226 | | |
| ALLOY | 1100 | TEMPER | O | FORM | COIL |
| GAGE | 06300 | WIDTH | 48.0000 | LENGTH | 0.0000 |

MILL FINISH
NON ANODIZE QUALITY
OUT: STANDARD MILL FINISH
IN: STANDARD MILL FINISH
NOT EMBOSSED

Alcoa Certification 0001275543

LOT: 464874 COIL: B01 DROP: 1P00427

| INGOT | SI | FE | CU | MN | MG | CR | NI | ZN | TI |
|---------|------|------|------|------|------|------|------|------|------|
| 1P00427 | 0.11 | 0.45 | 0.13 | 0.01 | 0.01 | 0.01 | 0.01 | 0.01 | 0.01 |

HEAD ULTIMATE STRENGTH 14.4 KSI
TAIL ULTIMATE STRENGTH 14.4 KSI
HEAD YIELD STRENGTH (OFFSET = .2%) 5.8 KSI
TAIL YIELD STRENGTH (OFFSET = .2%) 6.7 KSI
HEAD ELG IN 2 IN., AT FRACTURE 31.5 %
TAIL ELG IN 2 IN., AT FRACTURE 32.5 %

CHEMICAL COMPOSITION ACCORDING TO ASTM E-1251-07
CHEMISTRY EXPRESSED AS % W/N FOR EACH REPORTED ELEMENT
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-10

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:
ASME SB209 1100 O, ASTM B209-07 1100 O

** END OF CERTIFICATION **

THIS IS A NON STRUCTURAL PART.
ASTM B209 IS ACCEPTABLE ON THE BASIS
OF SIMILARITY WITH OTHER "M" DRAWINGS
USED FOR PROCUREMENT OF ALUMINUM
PARTS/MAT'L.

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Authorized By: JEFF KREADY, LAB SUPERVISOR